

Date: Tuesday, 4/18/2006 10:00:56 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ARM
Job Number	: 26662		Part Number	: D2012103
Estimate Number	: 10706		Drawing Number	: D2012 REV B2
P.O. Number	: N/A		Project Number	: N/A
This Issue	: 4/18/2006 S.O. No. : N/A		Drawing Revision	: B2
Prsht Rev.	: NC		Material	: N/A
First Issue	: N/A		Due Date	: 5/7/2006
Previous Run	: 24983		Qty:	5
Written By	:		Um:	Each
Checked & Approved By	:			
Comment	: Est Rev:I 02.04.03 Added Inspect level 3 NG			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 3.5700 f(s)/Unit Total : 17.8500 f(s)

Material: 304/316 Seamless SS tubing, 1/2" O.D. x .035" wall(M304TR0.500W.035)

Identify as D2012-101

Batch: M19408 x④ / m100928 x①

FF 06.05.10

5

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Punch to length as per Dwg D2012-103 & template D2012-103T1(41.00")

FF 06.05.10

5

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

FF 06.05.10

5

1-Deburr

MF 06.05.15

5

2-Bend D2012-103 as per template D2012-103T2 & Dwg D2012-103

MF 06.05.13

5

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

SB 06/05/24

5

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

DL 06/05/01

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 26/06/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/18/2006 10:00:57 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 26662

Part Number: D2012103

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



18/06/01 (5)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1 PACKAGING RESOURCE #1



SL 06/06/01 (5)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST206

SL 06/06/01 (5)

8.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SL 06/06/01 (5)

Job Completion



in 06.06.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

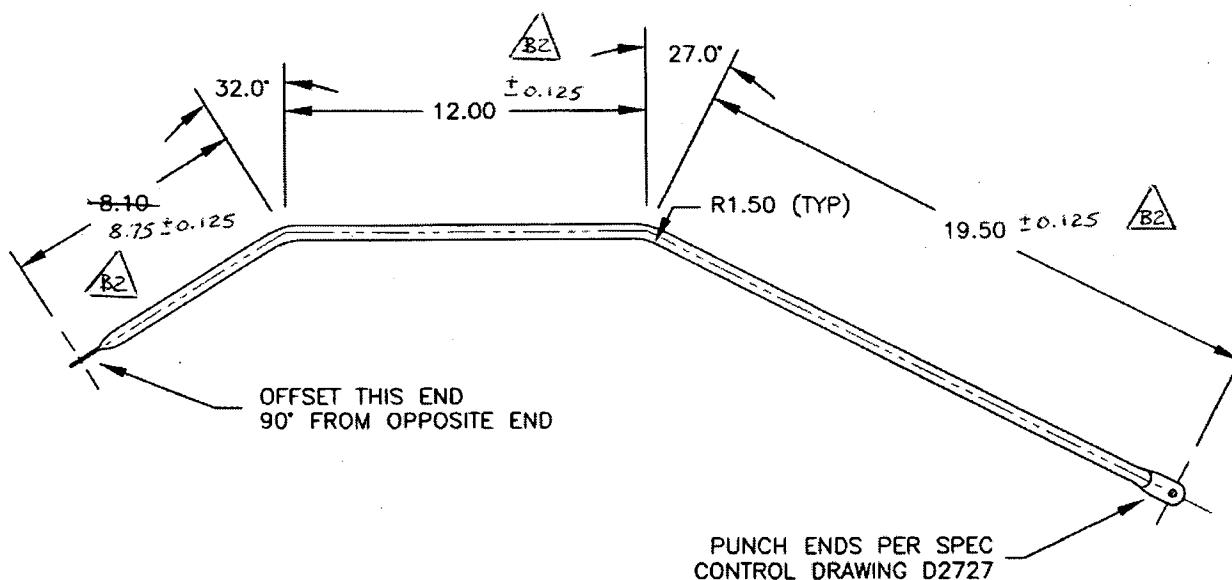
NOTE: Date & initial all entries

RELEASED

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
		HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>KE</i>	<i>KE</i>	D2012-103
DATE		SHEET 1 OF 1
98.04.28		SCALE
A	92.06.08	1:6
B	98.04.28	
<i>CP</i>	02.05.25	
32	05.04.27	
	NEW ISSUE	
	CHANGE ANGLES (TSR A362)	
	ADD FINISH	
	ADD TOLERANCE; 8.75 IN 8.10	



NOTES:

1. MAKE PER TEMPLATE DT8068 (WAS DT2012-103)
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.500 x 0.035 WALL
3. FINISH: POWDER COAT BLACK SANOTEX (4.3.5.7) PER DART QSI 445 4.3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *2662*